

Work Order ID 67960

Tuesday, April 05, 2011 10:10:02 AM



Page 1

Item ID: D412-698-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Door Roller, LH

Start Date: 4/5/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 4/11/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-04-5

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-698	Rev E								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-698-011 CHG003

Sulostoy

11-04-5bbels

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

fb

11/04/20

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

Sulostoy

(x2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-698-011

Location: _____

New B

14/04/4 (2)

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

11/5/4

ME

11-05-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 10:10:08 AM

Page 1

Work Order ID: 67960

Parent Item: D412-698-011

Parent Item Name: Cabin Door Roller, LH





Start Date: 4/5/2011

Required Date: 4/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from
Step 1, 3 KJ/DS
IPP Rev: D 08-01-28 change to rev D ECN 1104 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
S ₂ D3121-141  Bracket Assembly		Manufactured	No			100	Each	0.0000	3	6	✓		
S ₂ D3121-143  Bracket Assembly		Manufactured	No			110	Each	9.0000	1	2	✓		
				<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>				
				ST235A		9							
				61340		1							
				61406		8				61406			
S ₂ D3183-043  Bracket Assembly		Manufactured	No			110	Each	5.0000	1	2	✓		
				<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>				
				ST236		5							
				62001		5				62001			
S ₂ D3137-043  Bracket Assembly		Manufactured	No			110	Each	2.0000	1	2	✓		
				<u>Location</u>		<u>Loc Qty</u>			<u>Loc Code</u>				
				ST235B		2							
				62831		2							

67787 JB

JB

JB 11/04/20

62001

JB 11/04/20
68243

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 10:10:08 AM

Work Order ID: 67960



Parent Item: D412-698-011



Parent Item Name: Cabin Door Roller, LH

Start Date: 4/5/2011

Required Date: 4/11/2011

Start Qty: 2.00

Required Qty: 2.00

D3199-1

Manufactured No

110 Each

90.0000

9

18

✓



Bracket



JB

Location

Loc Qty

Loc Code

ST236A

90

61484

40

66830

50

66830

D3202-1

Manufactured No

110 Each

12.0000

1

2

✓



Cover



JB 11/04/20

Location

Loc Qty

Loc Code

ST241A

12

59693

4

66252

8

66252

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

REFERENCE ONLY**6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS**

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
		4				D3203-1	HANDLE
		1				D3220-041	DOUBLER
		1				D3220-042	DOUBLER
		2				D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
		8				AN960JD416L	WASHER
		8				MS21042L4	NUT (OR MS21042-4)
		16				MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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Revision: **E**

Date: 08.05.01

